

Work Order ID 87311

87311

Page 1

July-13-12 11:50:40 AM

Item ID: D407-802-018

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Passenger Door Opener Installation, RH

Start Date: 7/10/12 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 8/03/12 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12/07/13 Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------------|--------------|
| IIN-D407-802-1 | A |

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D407-802-018 CHG001

105

0.00

105

Pick Kit

Packaging

Memo

0.00

Packaging

110

0.00

110

QC4- 100% Inspect kits for completeness

QC

Memo

0.00

Quality Control

DA 16 12/07/13 002 JB

MLJ 12-10-12



12/10/12 JB

DA 16 12/07/13

(+)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

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July-13-12 11:50:40 AM

Item ID: D407-802-018

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Passenger Door Opener Installation, RH

Start Date: 7/10/12 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 8/03/12 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start *NR1*

QC: Date: SPC (Y/N): Date:

Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 120 | Packaging | 0.00 | | | | | | | |
| *120* | | | | | | | | | |
| Packaging | Memo | 0.00 | | | | | | | |
| Packaging | Identify and pack for shipping as per PPPD407-802-018 | | | | | | | | |
| | Location: <u>31</u> | | | | | | | | |
| | PPP rev: <u>3</u> | | | | | | | | |
| 130 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | |
| *130* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

MF
12-10-15

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 87311

Parent Item: D407-802-018

Parent Item Name: Passenger Door Opener Installation, RH

Start Date: 7/10/12

Required Date: 8/03/12

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 10.09.27 new issue DD verf:EC
rev.A DD verf:EC

IPP Rev:B 10.12.03 as per dwg

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|-------------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|-----------------|-------------|--------------|---------------|----------------|----------|
| D3552-17 Door Prop | | Manufactured | No | | | 105 | Each | 16.0000 | 1 | 88101 | 1 | 7B | |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | | |
| | | | | ST272 | | 15 | | | | | | | |
| | | | | 64338 | | 4 | | | | | | | |
| | | | | 65120 | | 1 | | | | | | | |
| | | | | 83585 | | 10 | | | | | | | |
| | | | | ST276 | | 1 | | | | | | | |
| | | | | 69670 | | 1 | | | | | | | |
| D3622-5 Ball Stud | | Manufactured | No | | | 105 | Each | 36.0000 | 1 | 82314 | 1 | 7B | |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | | |
| | | | | ST058 | | 36 | | | | | | | |
| | | | | 80406 | | 6 | | | | | | | |
| | | | | 82314 | | 30 | | | | | | | |
| D4108-3 Door Doubler, Right | | Manufactured | No | | | 105 | Each | 6.0000 | 1 | 79351 | 1 | 7B | |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | | |
| | | | | ST096 | | 6 | | | | | | | |
| | | | | 79351 | | 6 | | | | | | | |
| D4108-5 Small Right Door Doubler | | Manufactured | No | | | 105 | Each | 3.0000 | 1 | 79344 | 1 | 7B | 12/10/12 |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | | |
| | | | | ST096 | | 3 | | | | | | | |
| | | | | 79344 | | 3 | | | | | | | |

| W/O: | | WORK ORDER CHANGES | | | | | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 87311

Parent Item: D407-802-018

Parent Item Name: Passenger Door Opener Installation, RH

Start Date: 7/10/12

Required Date: 8/03/12

Start Qty: 1.00

Required Qty: 1.00

D4108-11
Template

Manufactured No

105 Each 10.0000

1 1 ✓ JB

Location

Loc Qty

Loc Code

ST096

10

79297

2

85048

8

79297

D4108-047

Sill Doubler Assembly

Manufactured No

105 Each 5.0000

1 1 ✓ JB

Location

Loc Qty

Loc Code

ST097

5

79352

5

79352

GR3523-4-02

RIVET

Purchased No

105 Each 579.0000

19 19 ✓ JB

Location

Loc Qty

Loc Code

GA

60

121114

60

ST332

519

116893

3

116915

1

120308

100

120422

15

120873

400

120873

CR3523-4-4

Rivet

Purchased No

105 Each 48.0000

4 4 ✓ JB 12/10/12

Location

Loc Qty

Loc Code

ST332

48

119717

48

119717

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Shop Packet Print

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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 87311

Parent Item: D407-802-018

Parent Item Name: Passenger Door Opener Installation, RH

Start Date: 7/10/12

Required Date: 8/03/12

Start Qty: 1.00

Required Qty: 1.00

MS20426AD4-6

Rivet

Purchased No

105 Each 1,617.0000

2 2 JB

Location

Loc Qty

Loc Code

ST317

1617

110139

187

118510

13

119436

417

121708

1000

MS21073L5

nut plate

Purchased No

105 Each 28.0000

121708 1 JB

Location

Loc Qty

Loc Code

ST303

28

120986

8

121444

20

MS27039C1-27

Screw

Purchased No

105 Each 7.0000

121444 2 JB

Location

Loc Qty

Loc Code

ST293

7

115768

7

NAS1149G0332R

Washer

Purchased No

105 Each 8,446.0000

115768 2 JB

Location

Loc Qty

Loc Code

297

8446

122063

8446

NAS1149G1165R

Washer

Purchased No

105 Each 57.0000

2 JB 12/10/12

Location

Loc Qty

Loc Code

ST296

57

115768

57

115768

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 87311

Parent Item: D407-802-018

Parent Item Name: Passenger Door Opener Installation, RH

Start Date: 7/10/12

Required Date: 8/03/12

Start Qty: 1.00

Required Qty: 1.00

NAS1149G0532R

WASHER

Purchased No

105 Each 205.0000

6 6 23 82

Location

Loc Qty

Loc Code

ST297

205

116373

1

116513

51

119736

153

NAS1149C0563R

Washer

Purchased No

105 Each 361.0000

6 6 23 12/10/12

Location

Loc Qty

Loc Code

ST296

200

120422

200

ST297

161

116391

8

117460

153

117460

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order
July-12
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Part Number: D407-802-018

Description: PASSENGER DOOR OPENER, RH

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5.3 D407-802-017/-018 Passenger Door Opener Kits

| Qty -017 | Qty -018 | Part Number | Description |
|-------------|-------------|---------------|-------------------------------|
| | | D407-802-017 | PASSENGER DOOR OPENER KIT, LH |
| | | D407-802-018 | PASSENGER DOOR OPENER KIT, RH |
| 1 | 1 | D3552-17 | DOOR PROP |
| 1 | 1 | D3622-5 | BALL STUD |
| 1 | | D4108-1 | DOOR DOUBLER, LEFT |
| | 1 | D4108-3 | DOOR DOUBLER, RIGHT |
| | 1 | D4108-5 | SMALL RIGHT DOOR DOUBLER |
| | 1 | D4108-11 | TEMPLATE |
| | 1 | D4108-047 | SILL DOUBLER ASSEMBLY |
| 1 | | D4108-049 | LITTER DOOR FITTING ASSEMBLY |
| | 19 | CR3523-4-2 | RIVET |
| 21 | | CR3523-4-3 | RIVET |
| | 4 | CR3523-4-4 | RIVET |
| 2 | | MS20426AD4-5 | RIVET |
| | 2 | MS20426AD4-6 | RIVET |
| 1 | 1 | MS21073L5 | ANCHOR NUT |
| 3 | | MS21209-F1-15 | HELICOIL |
| 3 | | MS27039C1-06 | SCREW |
| 1 | | MS27039C1-09 | SCREW |
| 2 | 2 | MS27039C1-27 | SCREW |
| 2 | 2 | NAS1149C0332R | WASHER |
| 2 | 2 | NAS1149C1165R | WASHER |
| 6 | 6 | NAS1149C0532R | WASHER |
| 6 | 6 | NAS1149C0563R | WASHER |

5.4 D407-802-019 Baggage Door Opener Kit, Composite

| Qty -019 | Part Number | Description |
|-------------|---------------|------------------------------------|
| | D407-802-019 | BAGGAGE DOOR OPENER KIT, COMPOSITE |
| 1 | D3552-19 | DOOR PROP |
| 1 | D4109-041 | DOUBLER ASSEMBLY, BULKHEAD |
| 1 | D4109-043 | DOUBLER ASSEMBLY |
| 3 | 80-004-2-6 | INSERT |
| 4 | MS27039C1-05 | SCREW |
| 3 | MS27039C1-06 | SCREW |
| 7 | NAS1149C0363R | WASHER |
| 4 | NAS1836-3-08M | INSERT |